

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023350**Date Inspected:** 10-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A

Bridge No: 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath Math was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

Orthotropic Box Girder (OBG) Trial Assembly Areas

4AW and 4BW (from Counter Weight to Cross Beam side)

This Quality Assurance (QA) Inspector witnessed final tension verification for U-Ribs to U-Ribs for Segment 4AE to 4BE between PP 25 to PP 26. Inspected 10% of bolt final tensioning found satisfactory. U-Ribs from 1 to 10 (Reference from Counter Weight to Cross Beam Side) completed the final verification and from 11 to 39 is balance. Bolt sizes used are M22 x 2.5 x 80 RC Set# DHGM220021 and final Torque required is 543 N-m. Manual Torque wrench is been used with Sr. No. X02-584 with calibration due date as 2009.06.26. The Inspection was scheduled from 0830 Hrs.

4AE to 4BE and 4AW and 4BW

This Quality Assurance (QA) Inspector signed off the document for 4AE to 4BE and 4AW to 4BW the documents were been held since 06.04.2009 for calibration certificate for torque wrench.

WELDING INSPECTION REPORT

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- 1.Lower Chevron Brace (North and South) for 4AE – PP24 Green Tag No. 23
- 2.Lower Chevron Brace (North and South) for 4AE – PP25 Green Tag No. 24
- 3.Lower Chevron Brace (North and South) for 4BE – PP26 Green Tag No. 25
- 4.Lower Chevron Brace (North and South) for 4BE – PP27 Green Tag No. 26
- 5.Lower Chevron Brace (North and South) for 4BE – PP28 Green Tag No. 27
- 6.Lower Chevron Brace (North and South) for 4AE – PP24 Green Tag No. 28
- 7.Lower Chevron Brace (North and South) for 4AE – PP25 Green Tag No. 29
- 8.Lower Chevron Brace (North and South) for 4BE – PP26 Green Tag No. 30
- 9.Lower Chevron Brace (North and South) for 4BE – PP27 Green Tag No. 31
- 10.Lower Chevron Brace (North and South) for 4BE – PP28 Green Tag No. 32
- 11.FB to BP Clips for 4AE – 4BE PP 24 to 27 Green Tag No. 38
- 12.Upper Chevron Brace (North and South) for 4AE to 4BE – PP24~28 Green Tag No. 39
- 13.FB to BP Clips for 4AE – 4BE PP 24-28 Green Tag No. 40
- 14.FB to BP Clips for 4AW – 4BW PP 24-27 Green Tag No. 41
- 15.FB to BP Clips for 4BE PP 28 Green Tag No. 42

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Math,Manjunath	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
